

Work Order ID 139259-2

Wednesday, November 18, 2015 8:51:55 AM

SPLIT 2

139259

RUSH

Page 1

Item ID: D4410-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Co-Pilot Collective Head

Start Date: 11/18/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/23/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: mf Date: 15-11-18 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4410	E

100	Cut blanks as per folio	0.00				5	0		DAS 20 9-89 15-11-20
-----	-------------------------	------	--	--	--	---	---	--	----------------------------

100

Bandsaw

Memo

Jeaspa Bandsaw

CUT BLANK AT 5.00"

110		0.00				4	0		DAS 20 9-89 15-11-25
-----	--	------	--	--	--	---	---	--	----------------------------

110

HAAS 1

Memo

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB078

FOLIO REV: AA

DWG REV: E

DO NOT BUFF OR POLISH PART****

DEBURR

Work Order ID 139259

Wednesday, November 18, 2015 8:51:55 AM

139259

Page 2

Item ID: D4410-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot Collective Head

Start Date: 11/18/2015 Start Qty: 5.00 ***5***

Cust Item ID:

Required Date: 11/23/2015 Req'd Qty: 5.00 ***5***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		DAS 20 9-89 15-11-25
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00				4			15-11-26
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: _____	0.00				4			DAS 8 15-11-26
140									
Packaging	Memo	0.00							
Packaging	LOCATION: WA001								

NOV 27 2015

Work Order ID 139259

Wednesday, November 18, 2015 8:51:55 AM

139259

Page 3

Item ID: D4410-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head
 Start Date: 11/18/2015 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 11/23/2015 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MLJ 15-11-27
 MLJ 15-11-27

Picklist Print

Wednesday, November 18, 2015 8:51:53 AM

Page 1

Work Order ID: 139259

139259

Parent Item: D4410-1

D4410-1

Parent Item Name: Co-Pilot Collective Head

Start Date: 11/18/2015

Required Date: 11/23/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 11/11/16 JFS VERIFY BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B4 500X4 500		Purchased	No			100	f	4.7860	0.42	2.210526			DAS
									**	2.1671			20 15-11-20
M6061T6B4 500X4 500													
6061-T6 Aluminum Bar 4.500" X 4.500"													

Location

Loc Qty

Loc Code

MAT

4.786

m131700

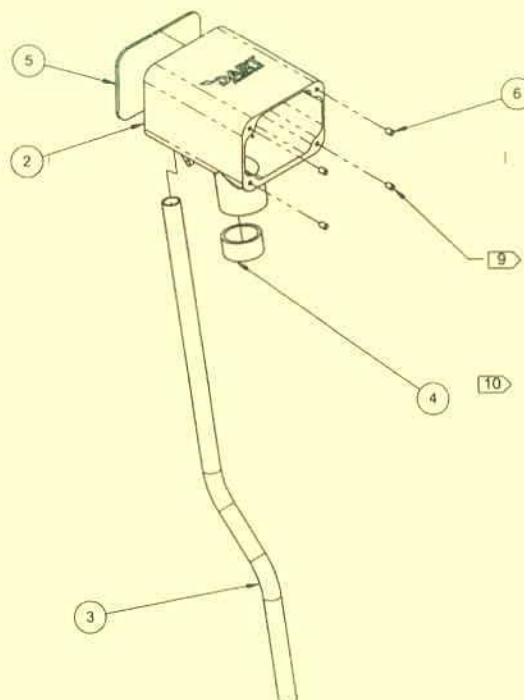
0.9

m132876

3.886

2.1671

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4410-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-11	205 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)



NOTES

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.57 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

RELEASED

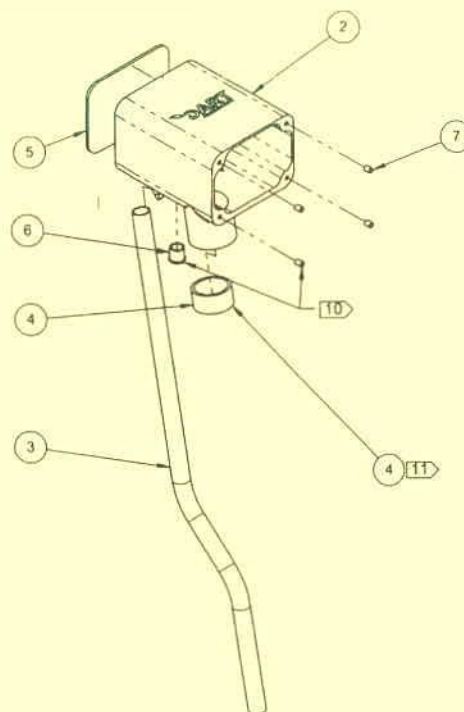
2015 JUL 02 *EN 15-577*
A.P.

D4410-041 WELDING DETAIL

REV	DESCRIPTION	BY	DATE
E	REVISE DIMS. ZN D5-7, D6-7, D7-4, C6-4, D6-4, C8-4, D5-4, C5-5, B7-6, B6-6, B4-6, C4-6, B6-7, B5-7, C4-7, ADD DIM D5-9, REMOVE PIN FROM BOM. ZN D5-1, D5-2, D5-3, REVISE NOTES, ZN A8-2, A8-3, A8-4, REVISE NECK LENGTH AND REMOVE MOUNTING HOLE. ZN C6-4, REMOVE MOUNTING HOLE. ZN C5-10, C5-11	VS	15.05.28
D	REVISE TRIGGER SHAPE, ZN A5-9, REVISE C'BORE, ZN A6-4, REVISE HOLE DIM, ZN D5-8	VS	14.10.14
C	ADD HOLE DIM, ZN C6-7, UPDATE LOGO, ZN C2-5, UPDATE NOTE 8, ZN A8-5, REVISE CAPTION, ZN B2-1; ADD WELDING DETAIL, ZN C2-2, ZN C2-3	VS	14.02.20
B	ADD C'BORE, ZN A4-2, ENLARGE HOLES, ZN C5-3 & B8-3, UPDATE LOGO, ADD -045/-11/-13/-15, ROTATE HOLE, ZN C3-2 INCREASE .7 DIAMETER, ZN C1-6, REMOVE -9 FROM -041 ASSEMBLY, ZN C5-1	DC	12.07.30
A	NEW ISSUE	DC	11.06.06
DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	EPOMA	D4410	SHEET 1 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	D8	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.28	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR DISTRIBUTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

APPROVED

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4410-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	1	D4413-1	DOME PLUG
7	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)



D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

RELEASED
P. 2015 JUL 02

D4410-043 WELDING DETAIL

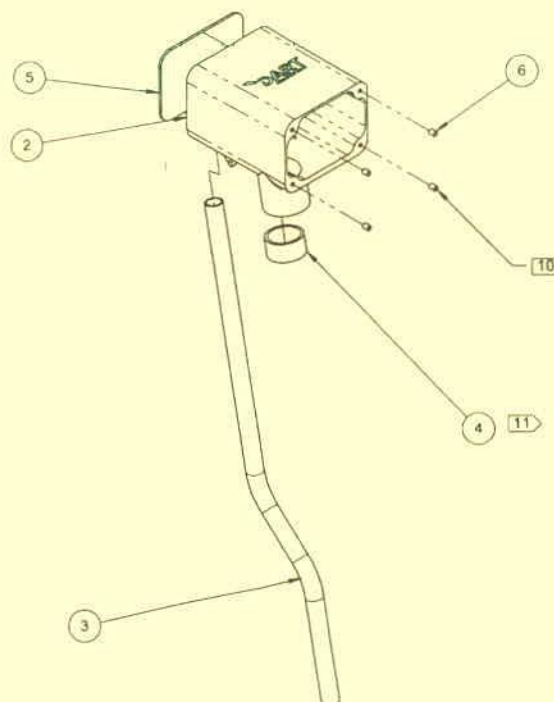
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.57 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

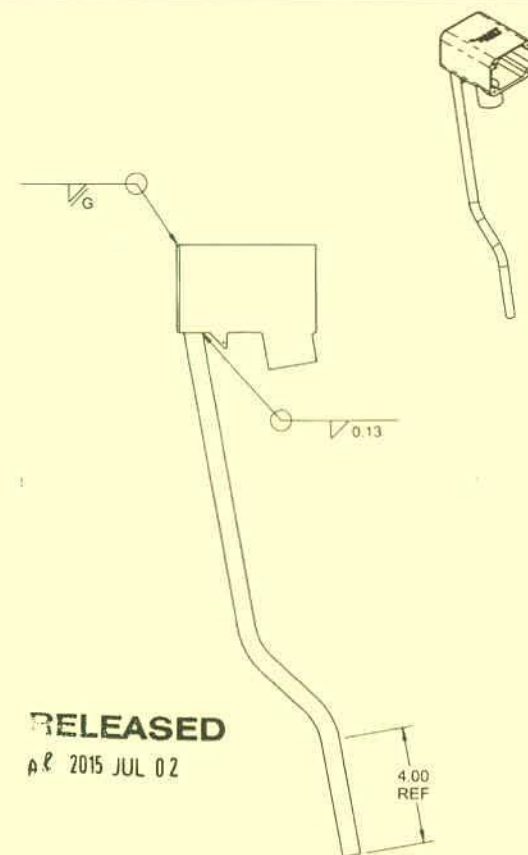
APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	EPDMA	D4410	SHEET 2 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.28	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	

ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4410-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)



**D4410-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY
(EAGLE SINGLE)**



D4410-045 WELDING DETAIL

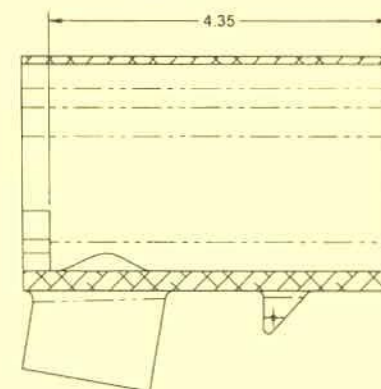
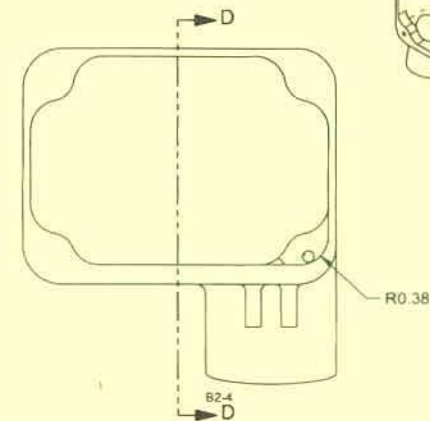
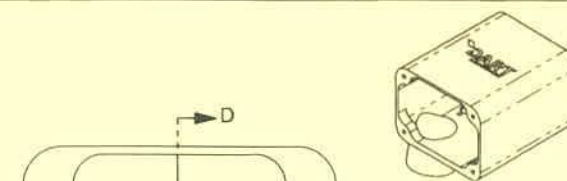
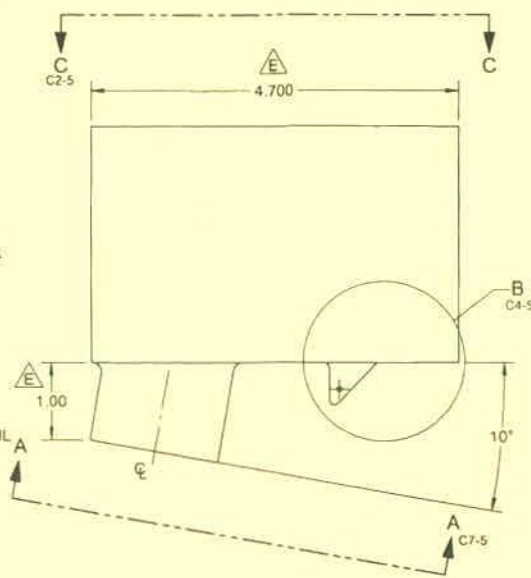
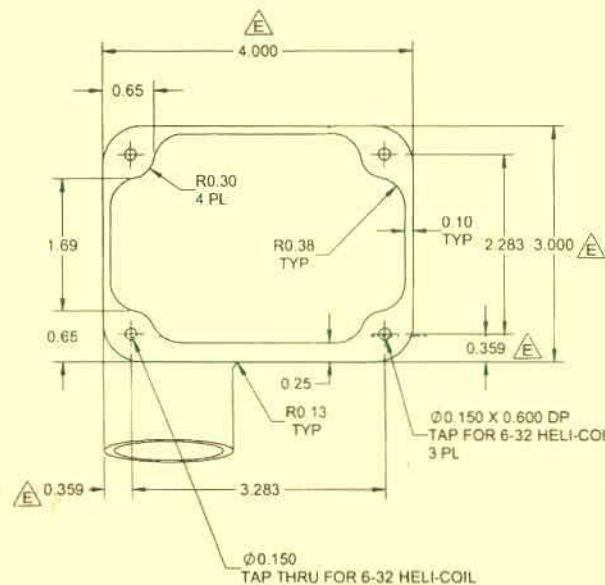
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.57 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

RELEASED
AR 2015 JUL 02

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	EPDMA	D4410	SHEET 3 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.28	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	



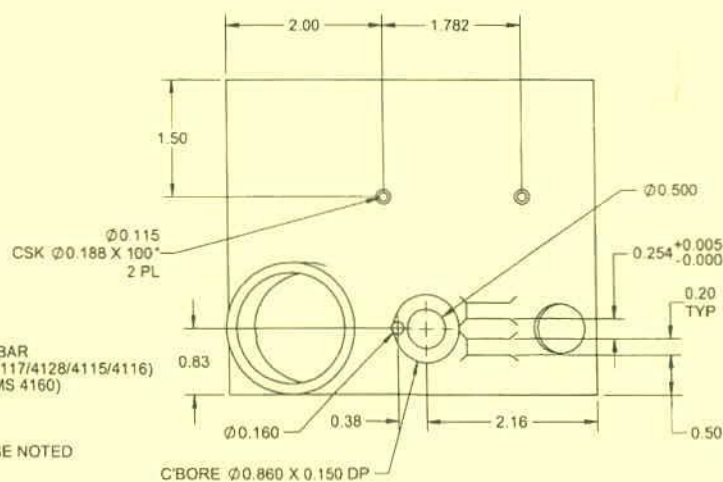
SECTION D-D
D2-4

RELEASED

REL 2015 JUL 02

NOTES:

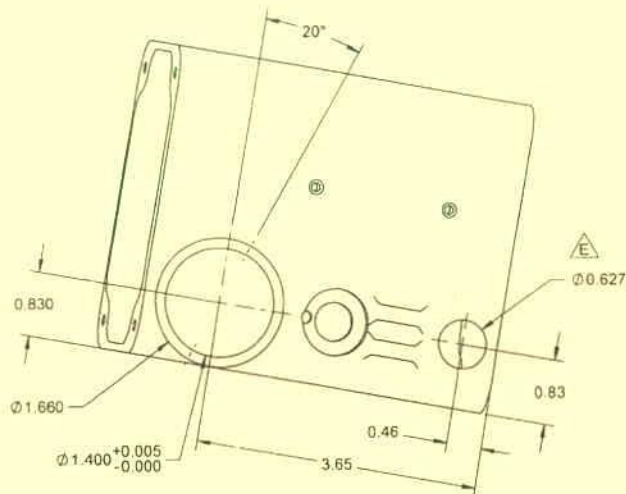
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/B OR AMS-QQ-A-225/B (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/B OR AMS-QQ-A-200/B (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B4.000X3.000
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.26 lbs



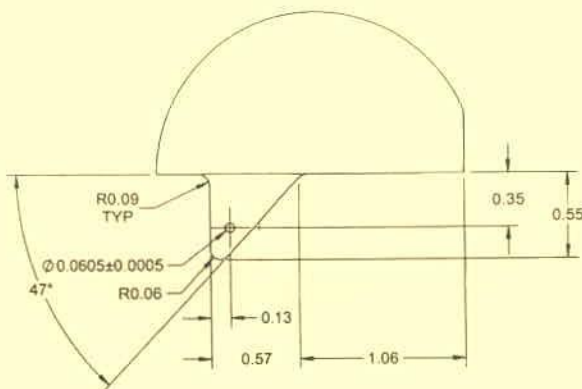
D4410-1 CO-PILOT COLLECTIVE HEAD

APPROVED

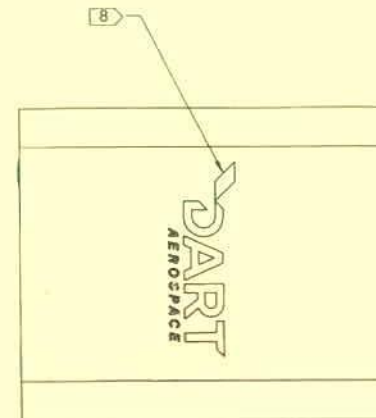
DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	EPDMA	D4410	SHEET 4 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	15.05.28	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC.	



VIEW A-A
C5-4



DETAIL B
C4-4



VIEW C-C
D4-4

**D4410-1 CO-PILOT COLLECTIVE HEAD
DETAIL VIEWS**

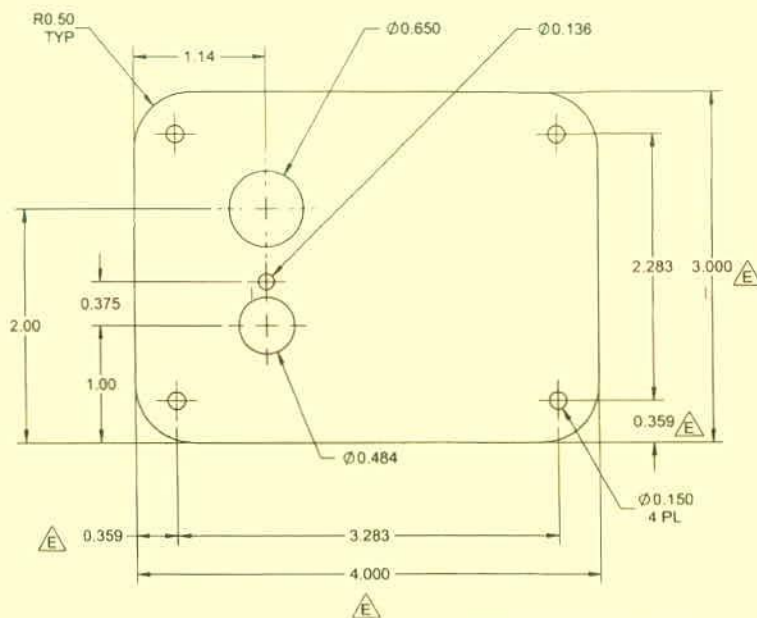
RELEASE
A.P. 2015 JUL 02

NOTES:

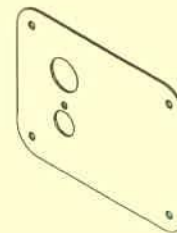
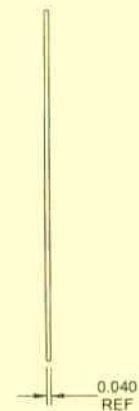
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. E
MFG APPR.	EPDMA	D4410	SHEET 5 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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D4410-3 FACE PLATE

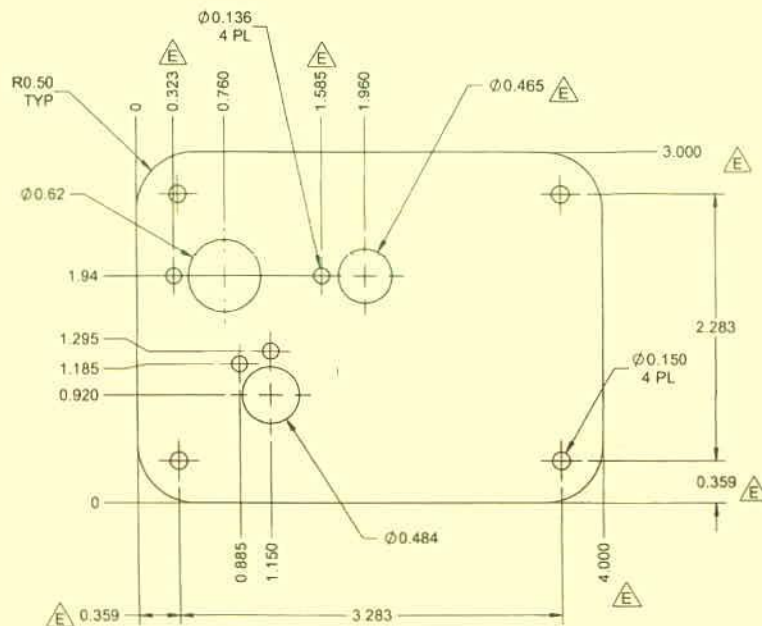


NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
AR 2015 JUL 02

APPROVED	DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	VS		
	CHECKED	RF	DRAWING NO. D4410	REV. E
	MFG. APPR.	EPDMA	SHEET 6 OF 12	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD NTS	
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RELEASE
AR 2015 JUL 02

D4410-5 FACE PLATE

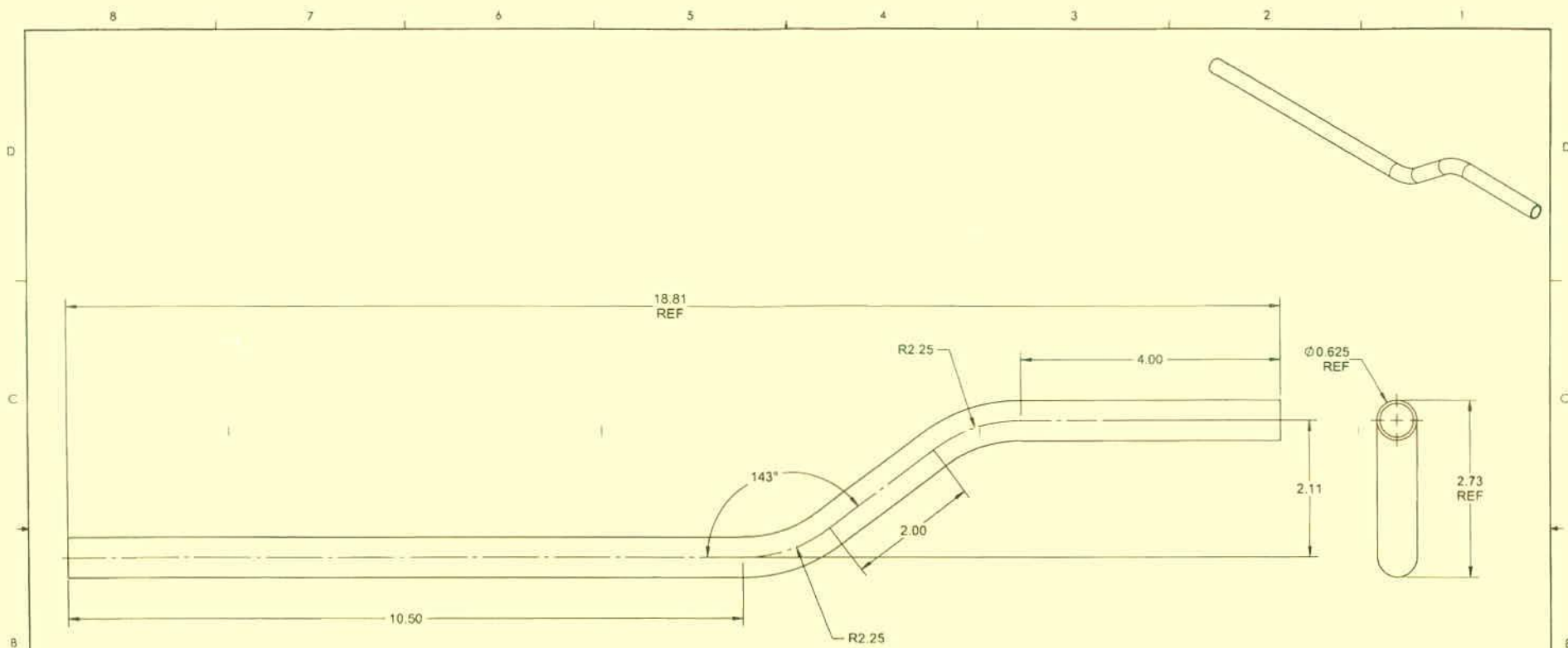
NOTES

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. E
MFG APPR.	EPDMA	D4410	SHEET 7 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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D4410-7 CONDUIT

RELEASE

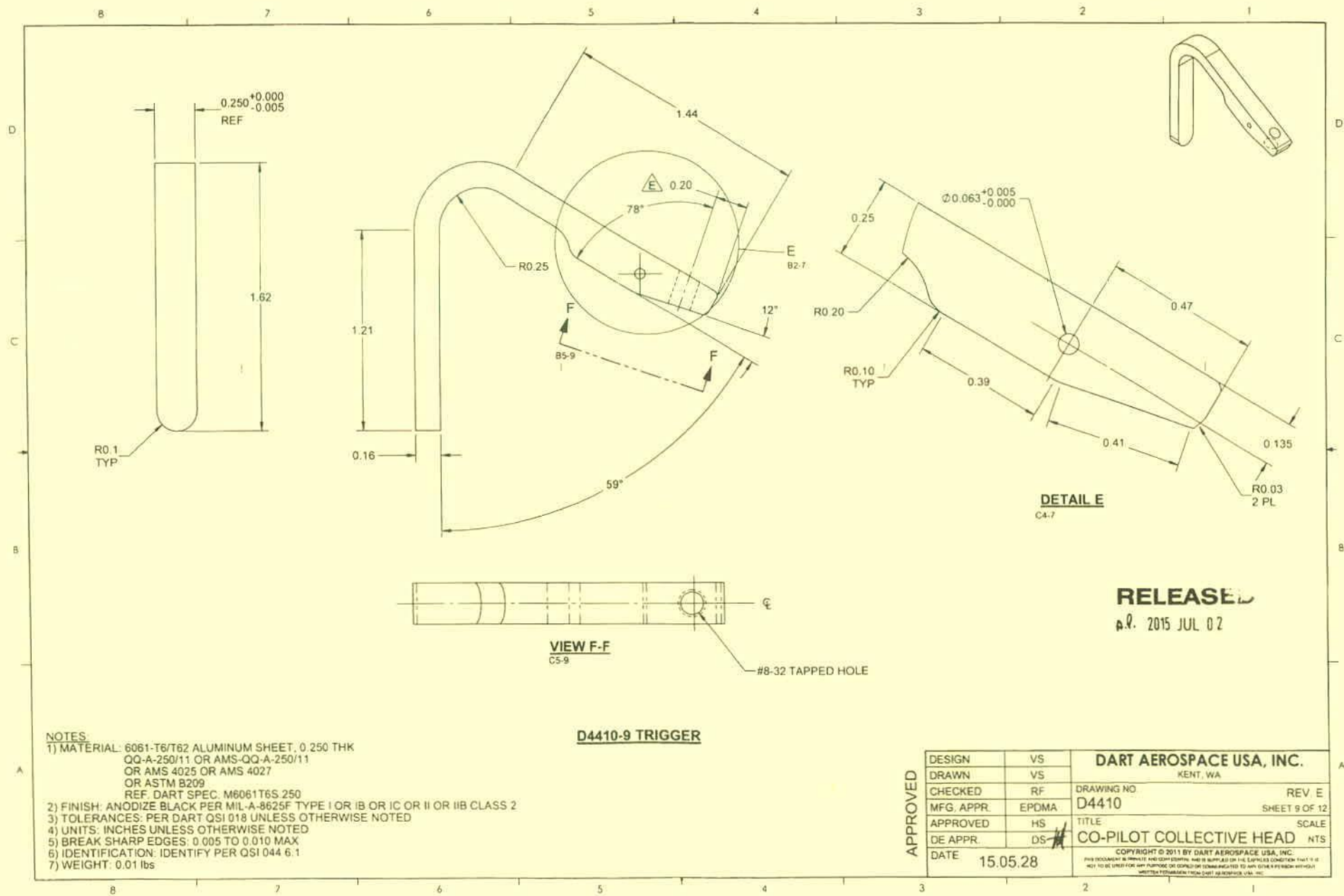
2015 JUL 02

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER
WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T60.625W.050
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs

APPROVED

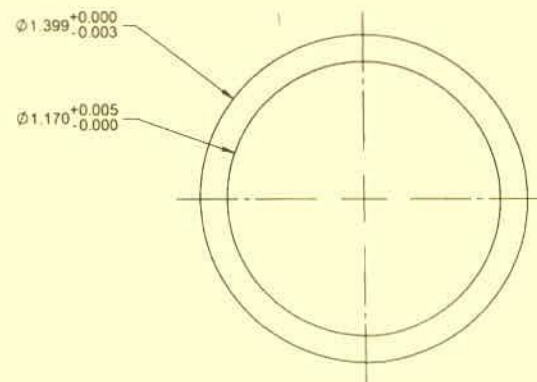
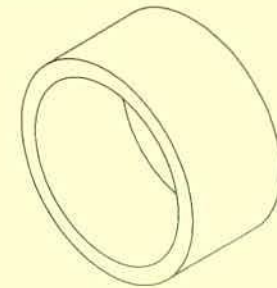
DESIGN	VS	DART AEROSPACE USA, INC.	
DRAWN	VS	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	EPDMA	D4410	SHEET 8 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.250 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.250
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.01 lbs

D4410-9 TRIGGER

APPROVED	DESIGN	VS	DART AEROSPACE USA, INC.	
	DRAWN	VS	KENT, WA	
	CHECKED	RF	DRAWING NO.	REV E
	MFG. APPR.	EPDMA	D4410	SHEET 9 OF 12
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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D4410-11 205 SHIM

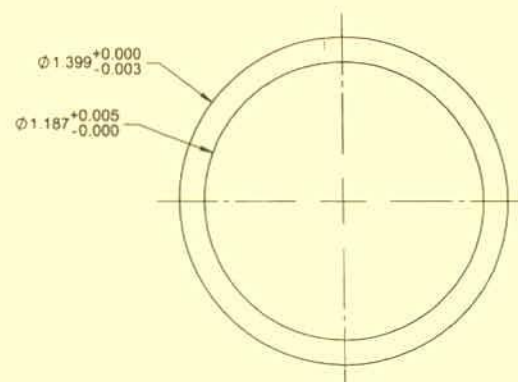
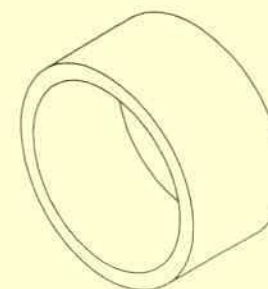
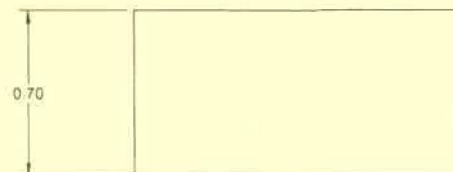
RELEASED
p.p. 2015 JUL 02

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO. D4410	REV. E
MFG. APPR.	EPDMA	SHEET 10 OF 12	
APPROVED	HS	TITLE CO-PILOT COLLECTIVE HEAD	
DE APPR.	DS	NTS	
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D4410-13 212 SHIM

NOTES:

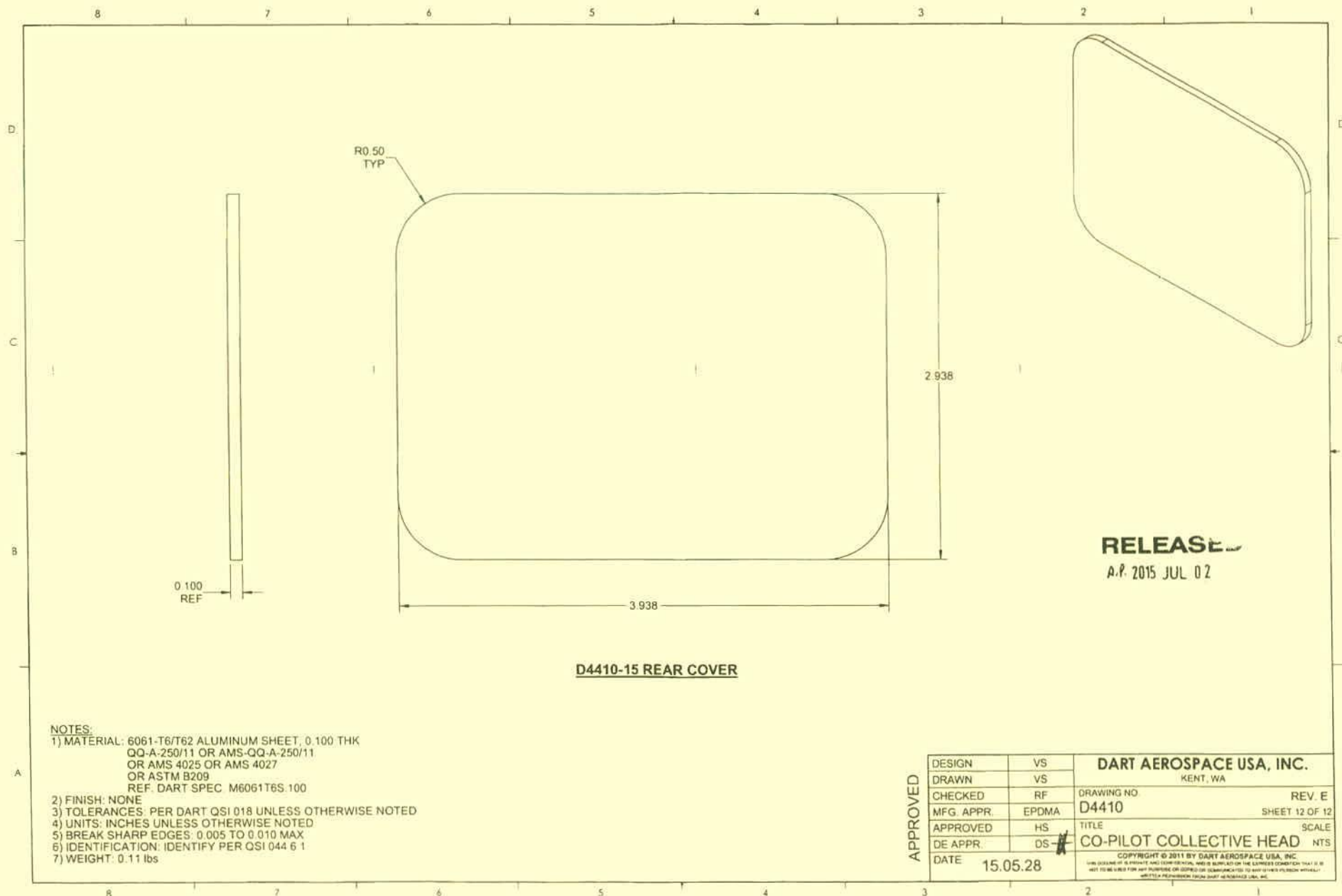
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

RELEASED

P.P. 2015 JUL 02

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO	REV. E
MFG. APPR.	EPOMA	D4410	SHEET 11 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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RELEASE

A.P. 2015 JUL 02

D4410-15 REAR COVER

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK
 QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF. DART SPEC M6061T6S.100

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6 1

7) WEIGHT: 0.11 lbs

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	RF	DRAWING NO	REV. E
MFG APPR	EPDMA	D4410	SHEET 12 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR	DS	CO-PILOT COLLECTIVE HEAD	NTS
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DART AEROSPACE LTD		Work Order:	139259
Description: Co-Pilot Collective Head		Part Number:	D4410-1
Inspection Dwg: D4410 Rev: E		Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.000	+/-0.010	4.006	✓		SL10	Vern
0.65	+/-0.030	.650	✓			
1.69	+/-0.030	1.690	✓			
0.65	+/-0.030	.650	✓			
0.359	+/-0.010	.358	✓			
3.283	+/-0.010	3.283	✓			
0.25	+/-0.030	.245	✓			
0.359	+/-0.010	.3535	✓			
0.10	+/-0.030	.103	✓			
2.283	+/-0.010	2.283	✓			
3.000	+/-0.010	2.996	✓			
R0.30	+/-0.030	.300	✓		Rad gauge	
R0.38	+/-0.030	.380	✓		"	
R0.13	+/-0.030	.125	✓		"	
Ø0.150	+0.005/-0.001	.151	✓		gauge Pin	
0.600 DP	+/-0.010	.600	✓		SL10	
6-32 Helicoil	N/A	6-32	✓			
4.700	+/-0.010	4.690	✓			
1.00	+/-0.030	.996	✓			
10°	+/-0.5°	10°	✓			
4.35	+/-0.030	4.350	✓			
1.782	+/-0.010	1.785	✓			
2.00	+/-0.030	1.994	✓			
1.50	+/-0.030	1.501	✓			
Ø0.115	+0.004/-0.001	.119	✓			
Ø0.188 x 100°	+0.005/-0.001 x +/-0.5°	.194 x 100°	✓			
0.83	+/-0.030	.832	✓			
Ø0.160	+0.005/-0.001	.160	✓		gauge Pin	
0.38	+/-0.030	.378	✓			
2.16	+/-0.030	2.153	✓			
0.50	+/-0.030	.510	✓			
0.20	+/-0.030	.197	✓			
0.254	+0.005/-0.000	.255	✓			
Ø0.500	+0.006/-0.001	.500	✓			
Ø0.860	+0.010/-0.001	.860	✓			
0.150 DP	+/-0.010	.150	✓			
0.830	+/-0.010	.838	✓			
Ø1.660	+0.012/-0.001	1.658	✓			
Ø1.400	+0.005/-0.000	1.405	✓		SL02	Mic

DART AEROSPACE LTD		Work Order:	
Description: Co-Pilot Collective Head		Part Number:	D4410-1
Inspection Dwg: D4410	Rev: E	Page 2 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.65	+/-0.030	3.650	✓		SL10	
0.46	+/-0.030	.450	✓			
0.83	+/-0.030	.832	✓			
Ø0.627	+0.008/-0.001	.627	✓			
R0.09	+/-0.030	.090	✓			
Ø0.0605	+/-0.0005	.061	✓		gauge	Pia✓
R0.060	+/-0.010	.060	✓		Rad	gauge
0.13	+/-0.030	.122	✓			
0.57	+/-0.030	.570	✓			
1.06	+/-0.030	1.055	✓			
0.55	+/-0.030	.550	✓			
0.35	+/-0.030	.345	✓			
	DAS					

Measured by:	9-89	Checked by:	SL	QC Inspector:	
Date:	15-11-23	Date:	15-11-26	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	12.11.09	New Issue	KJ	
B	15.09.09	Dimensions updated per Dwg Rev E	KJ	